Work Order ID 94431

Tuesday, December 18, 2012 3:43:26 PM

94431

Item ID: D4078-1

Revision ID:

Item Name: Clamp Half

Start Date: 12/18/2012 **Start Qty:** 4.00

Required Date: 12/21/2012 **Req'd Qty:** 4.00

Reference:

Accept *N900040100* Setup Start *NS1* Stop *NS2*

4

4

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1* Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4078	B								
100		0.00							
100									
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blank 2.700" long								
110		0.00							
110									
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA929 Folio rev: A4 Dwg Rev: B								
	Deburr								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

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Work Order ID 94431

Tuesday, December 18, 2012 3:43:26 PM

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Item ID: D4078-1
Revision ID:
Item Name: Clamp Half

Start Date: 12/18/2012 **Start Qty:** 4.00 *4*
Required Date: 12/21/2012 **Req'd Qty:** 4.00 *4*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				(8)			DAV 25 12-10-19
	Memo	0.00							
130 *130* QC Quality Control	QC8- Inspect parts - second check	0.00	ark 12/12/19			8	0		
	Memo	0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				8		RG 121220	
	Memo	0.00							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
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Stop *NS2*

Cust Item ID:

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Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

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Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 121279 840 300° 9:10	0.00				8 ϕ		BL 12-12-20.	
	Memo	0.00							
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00				8			
	Memo	0.00 12 12 20							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: ST 92	0.00				8x		SP 13-01-11	
	Memo	0.00							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

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- Supplier ☐
- Engineering ☐
- Quality ☐
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Equip/Tooling	☐									
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Tuesday, December 18, 2012 3:43:26 PM

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Start Date: 12/18/2012 **Start Qty:** 4.00 *4*
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13/1/10 JD
MF 12-12-27

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
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- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling	☐									
Operator	☐									
Material	☐									
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Process	☐									
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_____

_____

_____

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Picklist Print

Tuesday, December 18, 2012 3:43:25 PM

Work Order ID: 94431
Parent Item: D4078-1
Parent Item Name: Clamp Half

Start Date: 12/18/2012 **Required Date:** 12/21/2012
Start Qty: 4.00 **Required Qty:** 4.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.250 6061-T6 Bar 1.25 x 1.25		Purchased	No			100	f	14.2158	**0.223**	**0.9389474**	JL 12-12-19		

Location	Loc Qty	Loc Code
MAT003	14.2158421	
122521	2.2158421	
123649	12	94

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
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FAULT CATEGORY

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☐ Burrs
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☐ Instructions Incomplete/Unclear
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☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	44931
Description: Clamp Half	Part Number:	D4078-1
Inspection Dwg: D4078 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	.204	✓		MTA 2-10	
R0.13	+/-0.030	.13	✓			
1.882	+/-0.010	1.882	✓			
0.310	+/-0.010	.310	✓			
0.375	+/-0.010	.375	✓			
R0.06	+/-0.030	.060	✓			
R0.73	+/-0.030	.73	✓			
R0.38	+0.010/-0.000	.383	✓		LG	
0.025	+/-0.010	.025	✓			
0.71	+/-0.030	.714	✓			
0.75	+/-0.030	.750	✓			
0.23	+/-0.030	.231	✓			

Measured by:		Audited by:		Preliminary Approval:	
Date:	12-12-19	Date:	12/12/19	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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AGAINST DEPARTMENT/PROCESS

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- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
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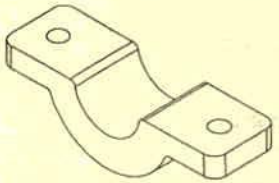

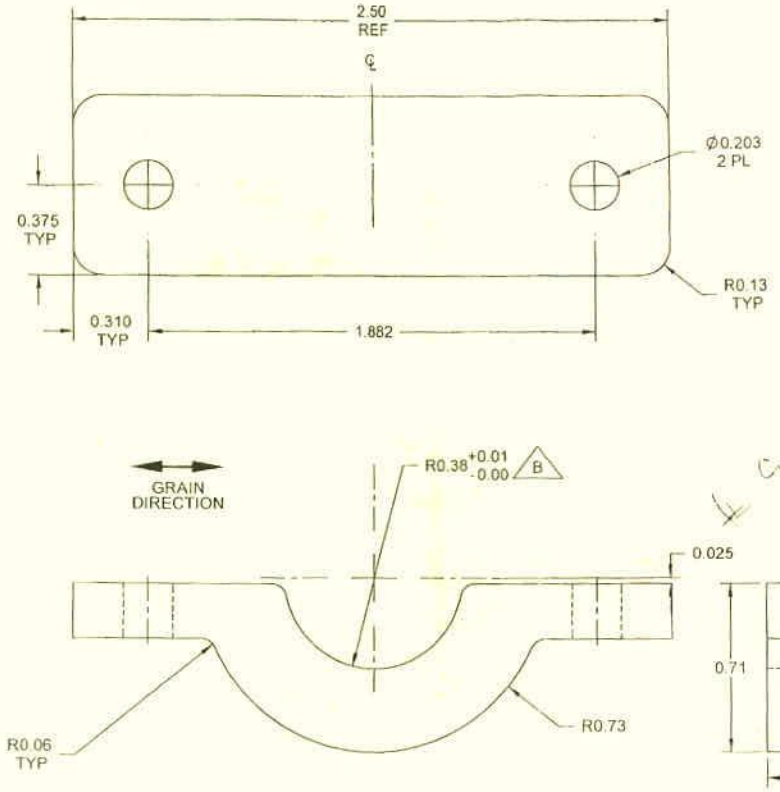

RELEASED
2010 -09- 07

D4078-1 CLAMP HALF

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

REV	DESCRIPTION	BY	DATE
B	R0.38 was R0.48	KB	10.07.30
A	NEW ISSUE	KB	10.02.08

DESIGN	KB
DRAWN	KB
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.07.30

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4078 REV. B
SHEET 1 OF 1
TITLE: CLAMP HALF
SCALE: NTS

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DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

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Rework ☐
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☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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